

Work Order ID 58709

May 17, 2010 1:23:48 PM



Page 1

Item ID: D3564-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 5/18/10

Start Qty: 16.00



Cust Item ID:

Required Date: 5/21/10

Req'd Qty: 16.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ☐ Dwg Rev: D ☐ Prog Rev: D ☐ 2-
Deburr if necessary

HB10-5-17



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB10-5-17

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S. 10/15/12



W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 58709

May 17, 2010 1:23:49 PM



Page 2

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Cust Item ID:

Required Date: 5/21/10 Req'd Qty: 16.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	NC BRAKE	0.00							
Brake NC	Memo	0.00				(22)			
Brake NC	Deburr if necessary <input type="checkbox"/> Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 <input type="checkbox"/> Form Joggle as per Dwg D3564 on brake using Jig DT8157								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00				(+22)			
Quality Control	Ensure joggle as per dwg D3429								
150 	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat	Memo	0.00				22	0		
Powder Coating	START TIME: 7:00 AM <input type="checkbox"/> FINISH TIME: 7:30 AM <input type="checkbox"/> OVEN TEMPERATURE: 320°F								

SP 10/05/18
E/S, 6/05/18

Sulostics

counts
(+22)

= 7 HU 10/05/19

W/O:		WORK ORDER CHANGES						
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Page 3

May 17, 2010 1:23:49 PM

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Item Name: Wearshoe

Start Date: 5/18/10 Start Qty: 16.00



Cust Item ID:

Required Date: 5/21/10 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

22

BR 10-5-19

170

Identify as per dwg & Stock Location: FP19

0.00



Packaging

Memo

0.00

Packaging

20 10/05/19

22

φ

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/2019

MF 10-5-19

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

May 17, 2010 1:23:46 PM

Page 1

Work Order ID: 58709



Parent Item: D3564-5



Parent Item Name: Wearshoe

Start Date: 5/18/10

Required Date: 5/21/10

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
IPP Rev D added DT# 08.04.21 DD Verified by EC

Start Qty: 16.00

Required Qty: 16.00

M304S16GA

Purchased

No

100

sf

97.3548

1.5

32.



304/316 Sheet .063

B 10-5-17

Location

Loc Qty

Loc Code

MAT

97.3548

111323

0

114467

97.3548

114467

(22)

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 58709
Description: Wearshoe		Part Number: D3564-5
Inspection Dwg: D3564	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
43.50	+/-0.030	43.56	✓			
6.75	+/-0.030	6.75	✓			
10.00	+/-0.030	10.00	✓			
20.00	+/-0.030	20.00	✓			
30.00	+/-0.030	30.00	✓			
2.50	+/-0.030	2.50	✓			
3.227	+/-0.010	3.224	✓			
38.500	+/-0.010	38.50	✓			
5.500	+/-0.010	5.501	✓			
2.50	+/-0.030	2.50	✓			
2.432	+/-0.010	2.438	✓			
0.300 x 0.300	+/-0.010	300x300	✓			
Ø0.188	+0.005/-0.001	.191	✓			
R0.375	+/-0.010	.375	✓			
0.063	+/-0.010	.059	✓			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 10-5-17	Date: 10/05/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	DD

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

D3564-1F FLAT PATTERN

RELEASED

07.09.04

W/O 58709

D3564-1 BENDING DETAIL (MAKE FROM D3564-1F)

D3564-3 BENDING DETAIL (MAKE FROM D3564-1F)

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT ϕ

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5, C5: ADD D3564-15; PG1 B6, B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ON PG1; PG3 B8, C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5, 7, B2: RELOCATE DETAILS AND SECTION; PG3 A5, 7, B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 1 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

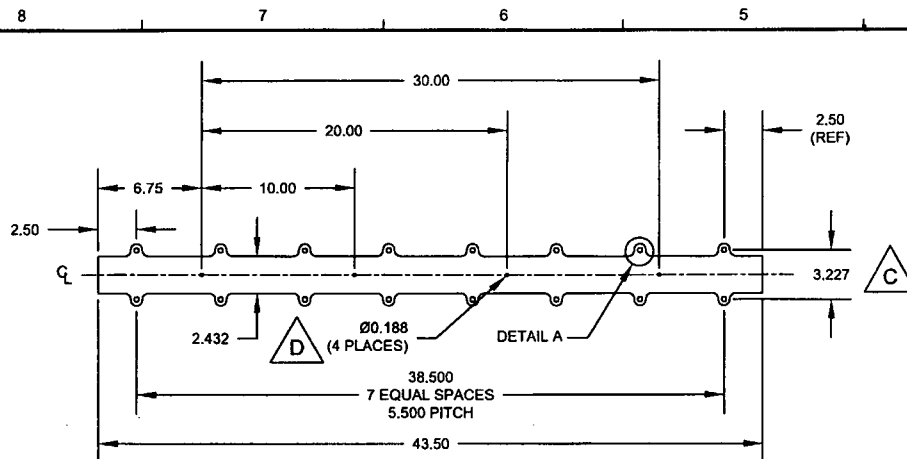
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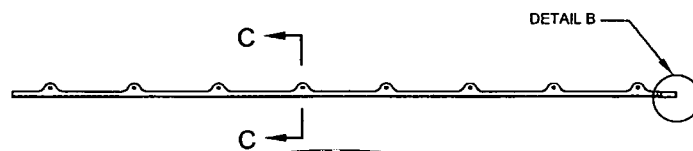
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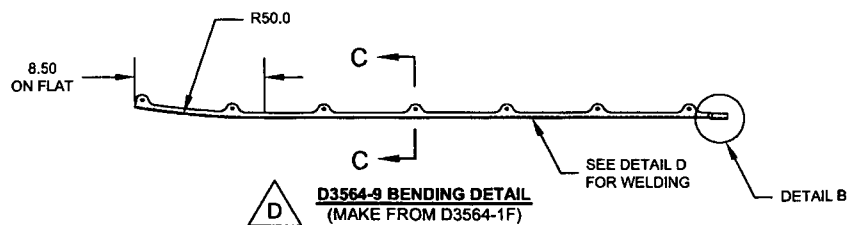
NOTE: Date & initial all entries



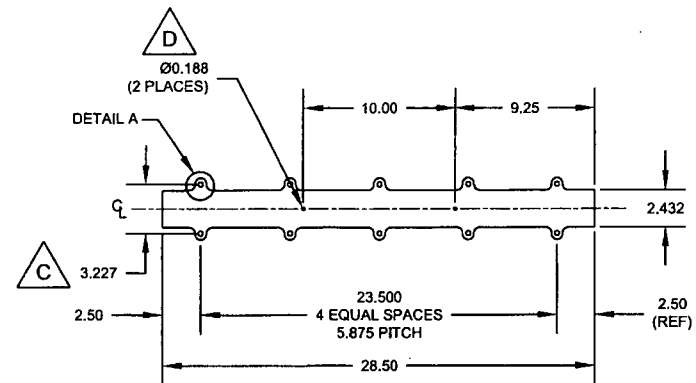
D3564-5F FLAT PATTERN



D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)

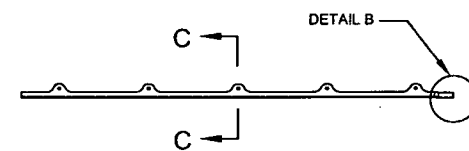


D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)

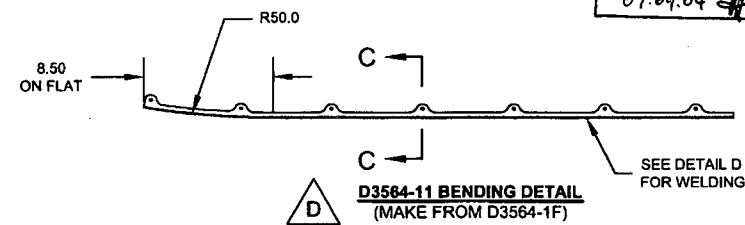


D3564-7F FLAT PATTERN

who 58709



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED
07.09.04

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
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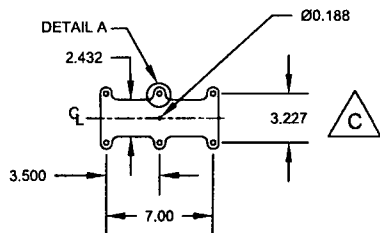
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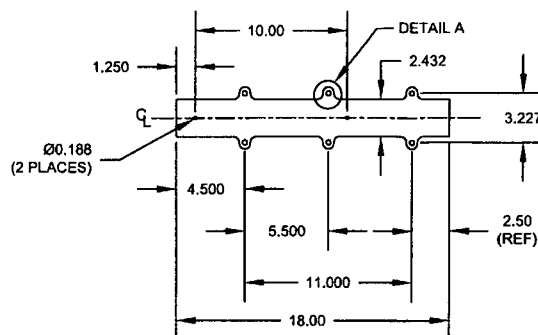
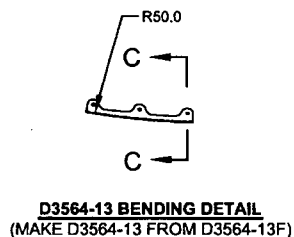
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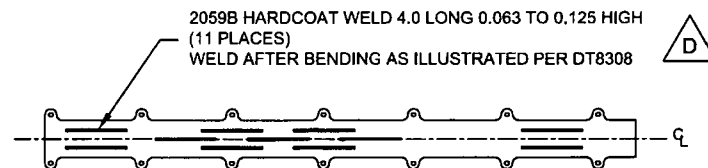
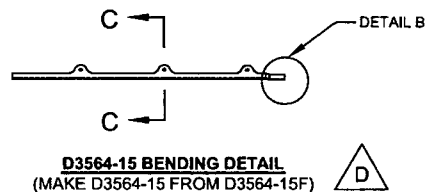
8 7 6 5 4 3 2 1



D3564-13F FLAT PATTERN



D3564-15F FLAT PATTERN

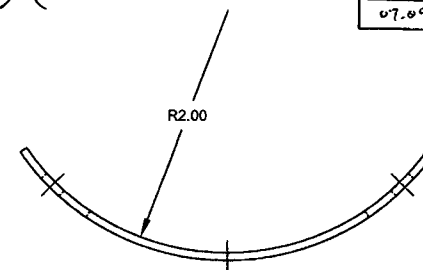


DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)

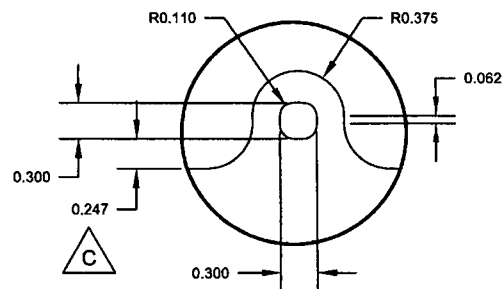
Handwritten: 58709

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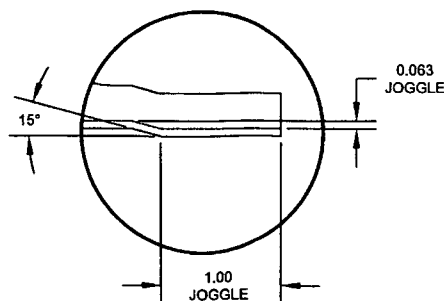
07.09.04



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
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8 7 6 5 4 3 2 1

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